

Date: Wednesday, 1/25/2006 1:22:06 PM  
User: Kim Johnston

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
<b>Job Number</b> : 25620	
<b>Estimate Number</b> : 10534	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2574
<b>This Issue</b> : 1/25/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2574 REV DE
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : DE
<b>Previous Run</b> : 2434	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 2/10/2006
<b>Checked &amp; Approved By</b> : JG 06.01.27	<b>Qty:</b> 12 <b>Um:</b> Each
<b>Comment</b> : Est: H 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
7075-T7351 8.25X5.0X2.5  
Make from D6101-005 billet for D2574  
Ensure that grain is along 5.00" length  
Batch No: B 23440

J.G 06/03/02 12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
Program Batch No. 25620 Double check by: JG

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove sharp edges.

Ep 06/03/09  
J.G 06/03/03 12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2573 & D2574

Ep 06/03/09 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 06/03/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/25/2006 1:22:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25620

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Ed 06/03/09

12

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/03/09

12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAP 06/03/12

12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ml 06/03/14

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DC 06/03/14

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 480

c 06/03/15

(12)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/15 (12)

Job Completion



U 06-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 25620
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.746	1.746		
C	3.495	3.505		3.498	3.496	3.497	3.496		
D	1.745	1.755		1.746	1.746	1.746	1.746		
E	7.990	8.010		8.004	8.006	8.005	8.004		
F	0.490	0.510		0.502	0.498	0.500	0.499		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.500	0.501	0.499		
J	1.174	1.184		1.176	1.178	1.177	1.177		
K	0.558	0.578		0.567	0.567	0.567	0.567		
L	1.174	1.184		1.176	1.178	1.177	1.177		
M	1.365	1.375		1.369	1.368	1.368	1.368		
N	2.495	2.505		2.498	2.497	2.495	2.495		
O	4.119	4.129		4.121	4.122	4.122	4.121		
P	0.115	0.135		0.124	0.124	0.126	0.120		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.252	0.252	0.253	0.247		
S	0.115	0.135		0.127	0.128	0.131	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.236	0.240	0.237		
W	0.115	0.135		0.123	0.124	0.125	0.125		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.624	0.627	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.244	0.247		
AE	1.500	1.520		1.510	1.510	1.512	1.505		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.266	0.260		
AH	0.240	0.260		0.252	0.252	0.254	0.252		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	En
Date:	06/03/06

Audited by:	MS
Date:	06/03/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 25620
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C	3.495	3.505		3.496	3.496	3.496	3.496		
D	1.745	1.755		1.746	1.746	1.746	1.747		
E	7.990	8.010		8.006	8.004	8.001	8.002		
F	0.490	0.510		0.499	0.499	0.500	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.502	0.502		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.566	0.567	0.567	0.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.495	2.495	2.495	2.499		
O	4.119	4.129		4.121	4.122	4.122	4.122		
P	0.115	0.135		0.123	0.124	0.123	0.123		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.250	0.252	0.251	0.250		
S	0.115	0.135		0.131	0.128	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.244	0.244	0.245		
W	0.115	0.135		0.127	0.126	0.125	0.124		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.625	0.627	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.250	0.254	0.253		
AE	1.500	1.520		1.508	1.510	1.508	1.507		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.254	0.251	0.249		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.020	0.030	0.030	0.030		
Accept/Reject									

Measured by: <u>S.G.</u>
Date: <u>06/03/07</u>

Audited by: <u>S.G.</u>
Date: <u>06/03/07</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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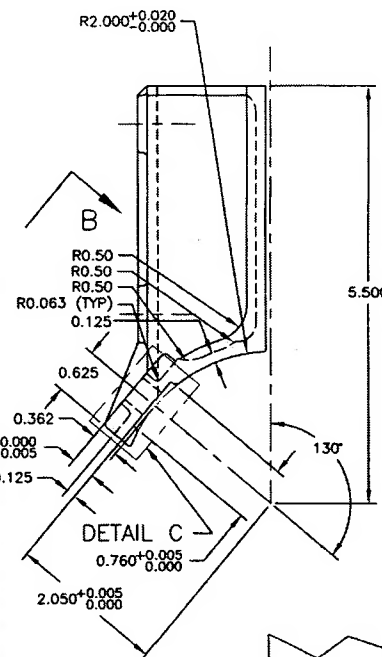
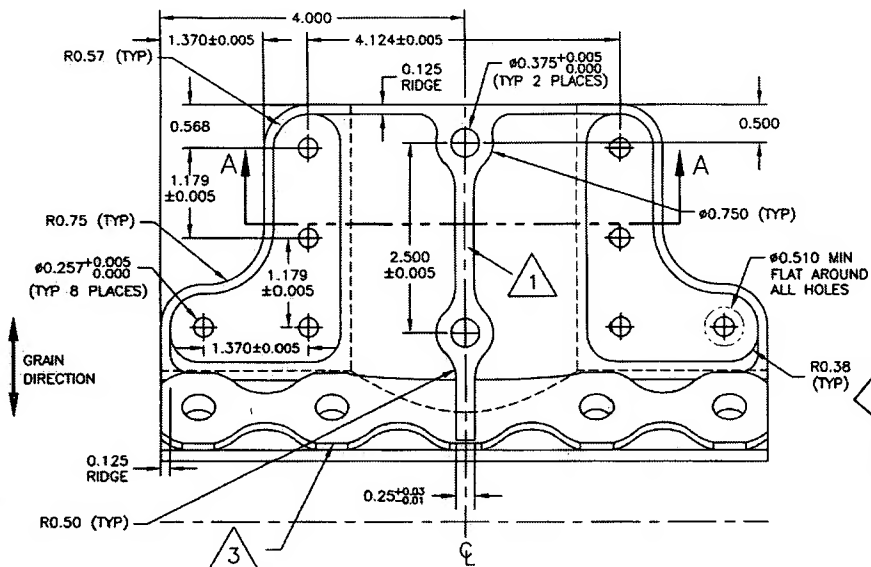
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C	3.495	3.505		3.508	3.501	3.506	3.501		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		8.002	8.002	8.006	8.004		
F	0.490	0.510		0.501	0.501	0.502	0.498		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.504	0.501		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.568	0.568	0.568	0.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.372	1.372	1.378	1.372		
N	2.495	2.505		2.499	2.499	2.500	2.499		
O	4.119	4.129		4.122	4.122	4.122	4.122		
P	0.115	0.135		0.130	0.129	0.123	0.125		
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AB	0.615	0.635		0.625	0.625	0.626	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
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AE	1.500	1.520		1.509	1.507	1.508	1.508		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.249	0.251	0.252		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: S.G.
Date: 06/03/07

Audited by: ED
Date: 06/03/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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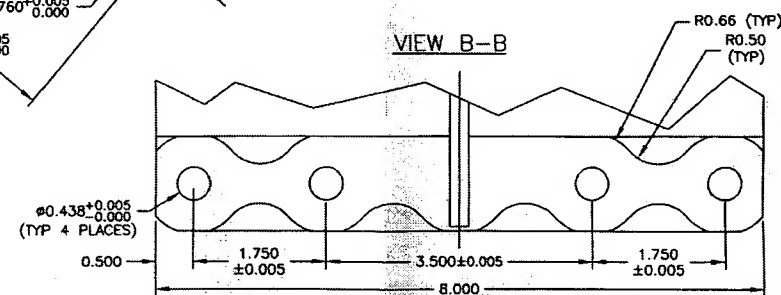
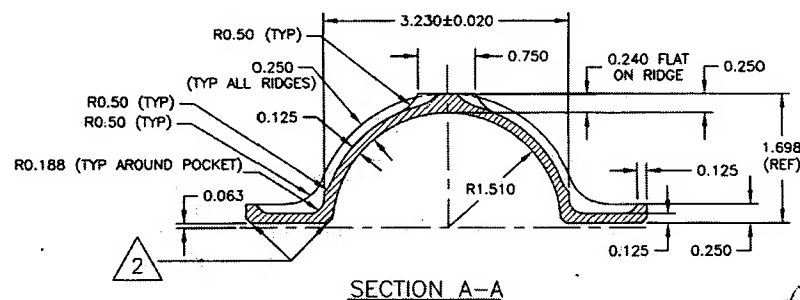
05.12.06 



## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



DETAIL C  
SCALE 2:1

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DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN <b>DS</b> CHECKED 		DRAWN BY <b>PH</b>  <b>DART AEROSPACE LTD.</b> MARKHAM, ONTARIO, CANADA DRAWING NO. <b>D2574</b> SCALE <b>1:1</b>
DATE <b>05.07.13</b>		TITLE <b>INNER AFT SADDLE</b> REV. 1 OF 1

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REQUIRE TO  
ENGINEERING  
SUBJECT TO APPROVAL  
DATE